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- (54) **PRESSURE REGULATOR BAFFLE SEAT WITH RADIAL FLOW PATHS**
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- (\*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.

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Primary Examiner—Stephen M. Hepperle

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- (52) U.S. Cl. .... **137/508; 123/459**
- (58) Field of Search ..... **137/508; 123/459**

(57) **ABSTRACT**

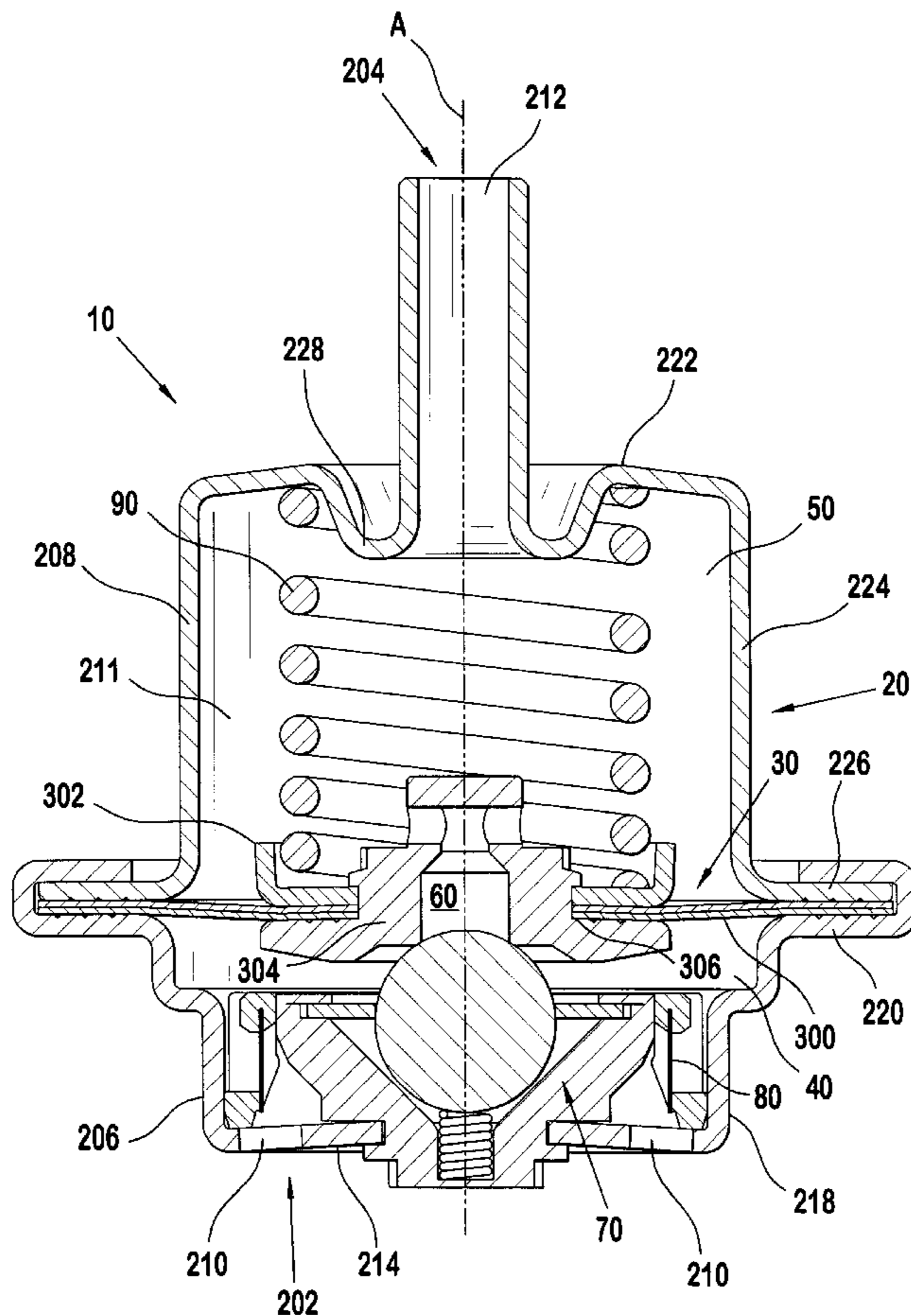
A flow-through pressure regulator includes a housing having an inlet and an outlet offset along a longitudinal axis. The housing is separated by a divider into a first chamber and a second chamber. The divider has a passage that communicates the first chamber with the second chamber. The passage includes a first section extending along the longitudinal axis and a second section extending transverse to the longitudinal axis. A closure member permits or inhibits flow through the passage.

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**20 Claims, 5 Drawing Sheets**



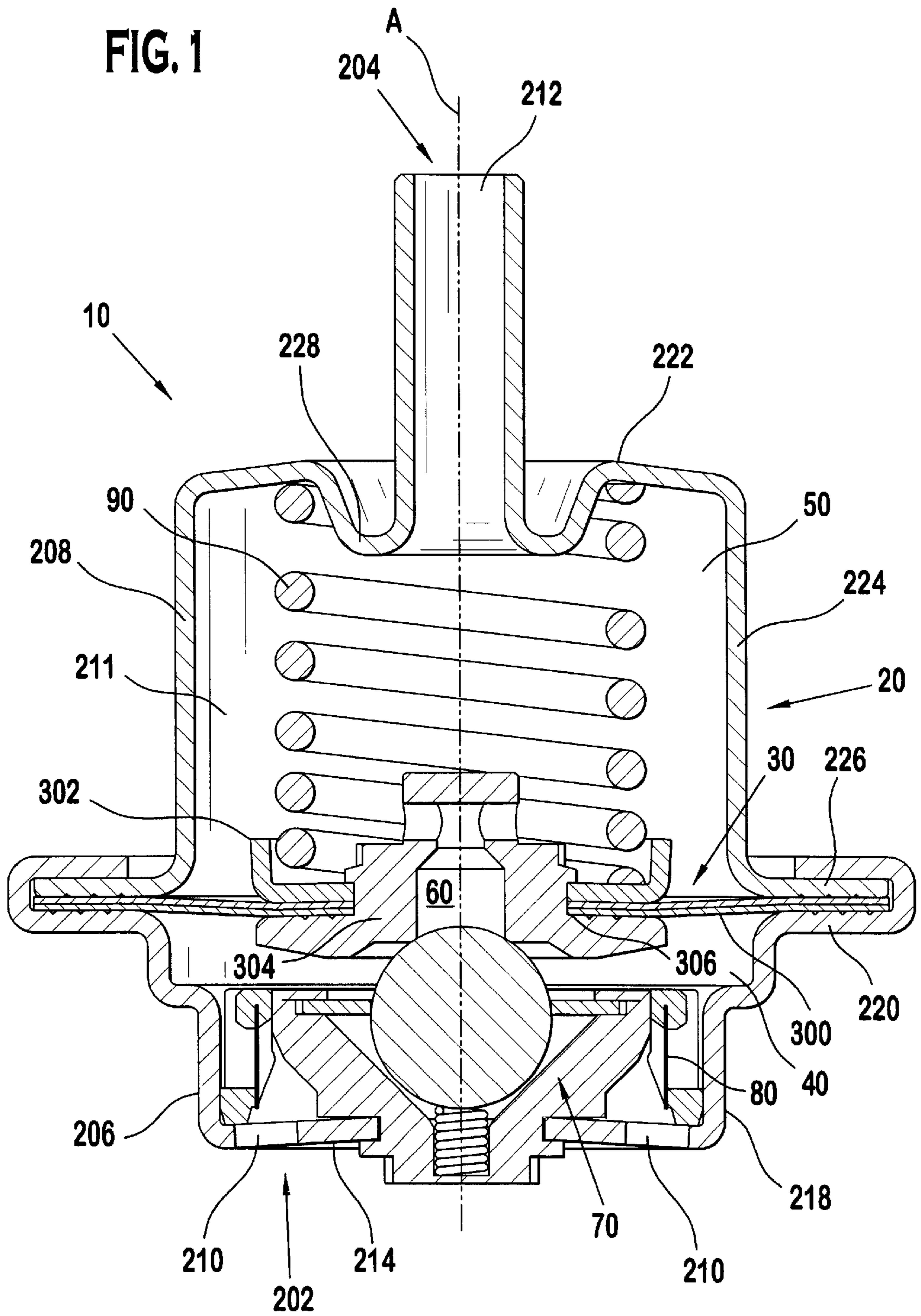


FIG. 2

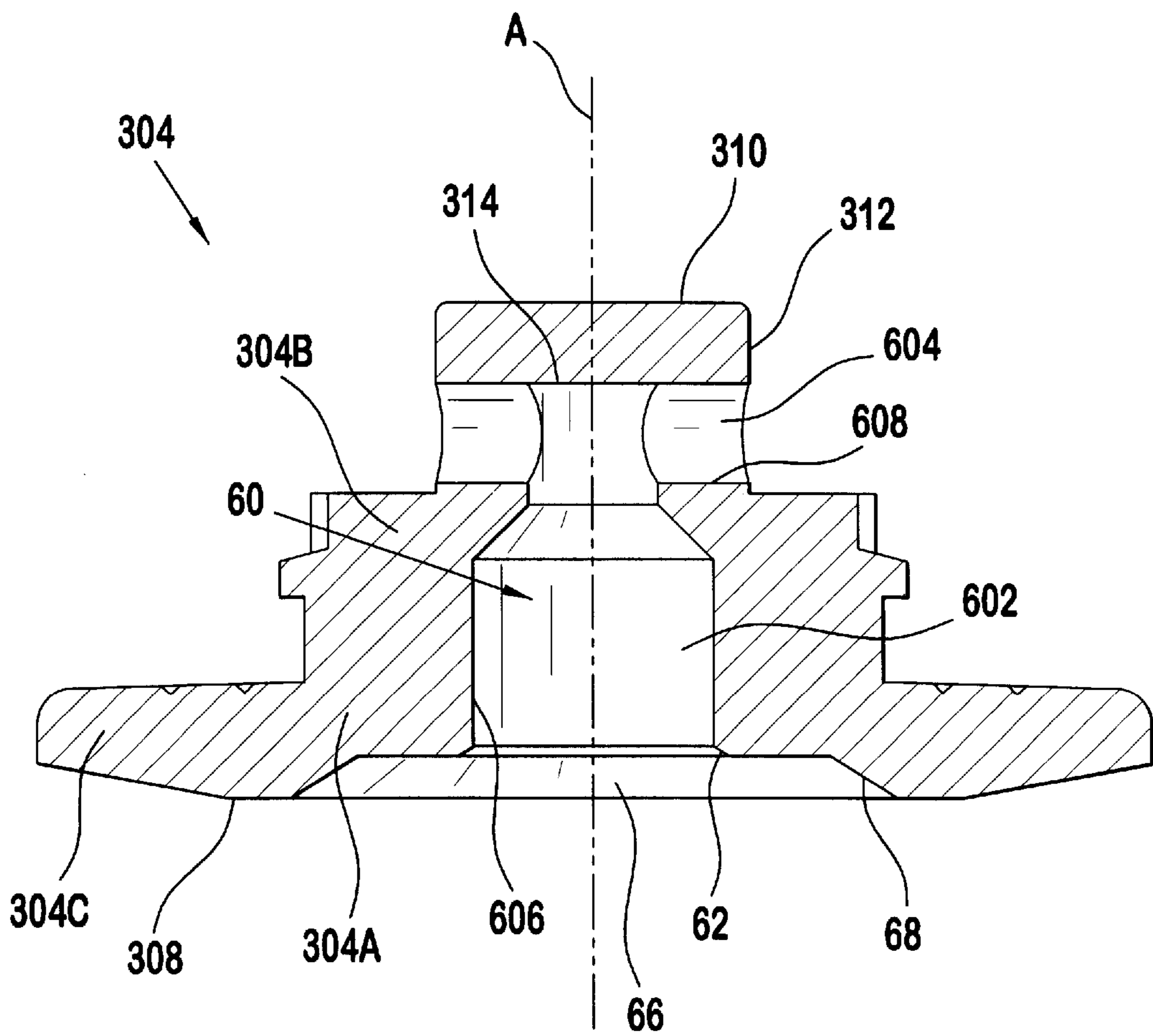


FIG. 3

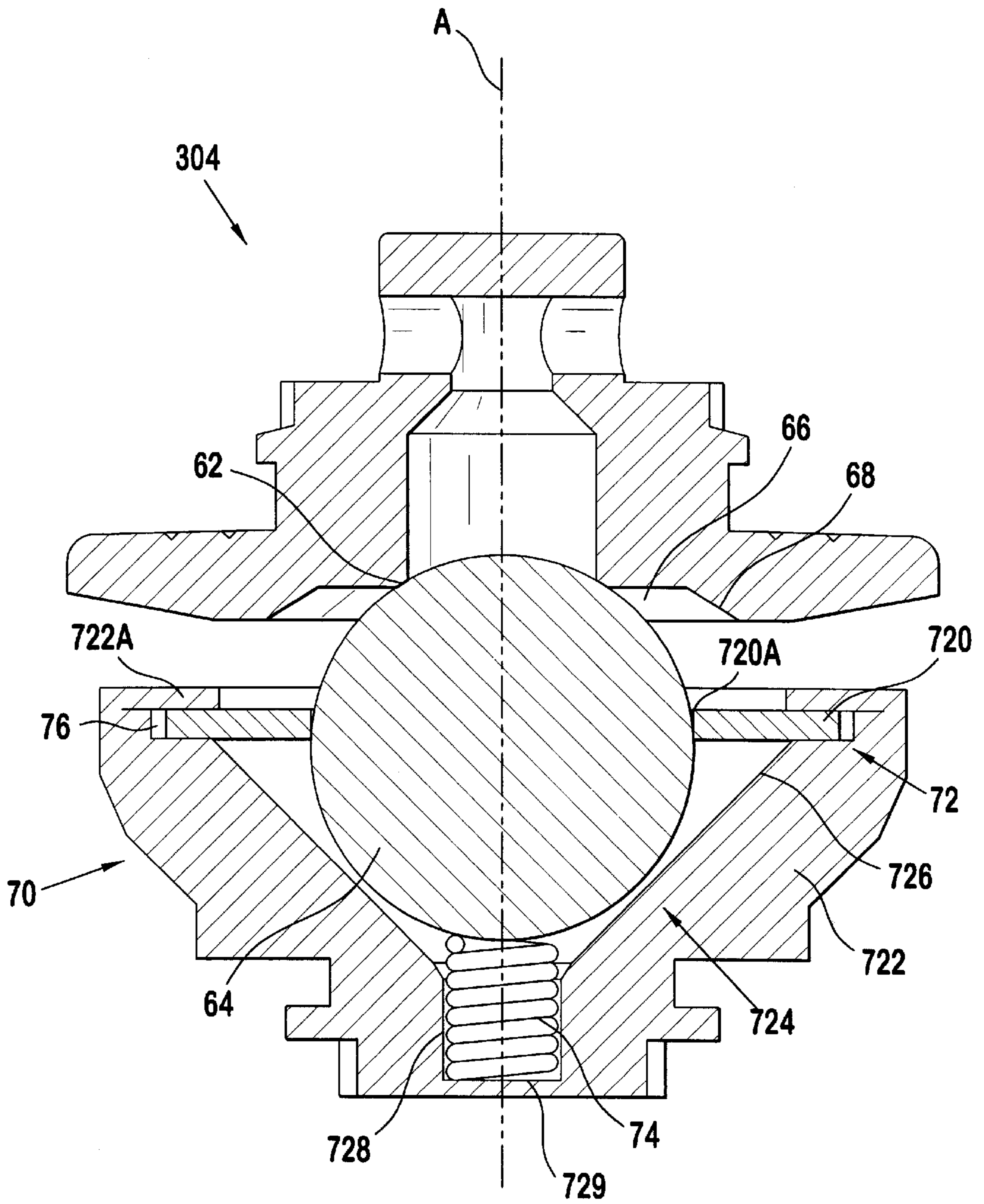
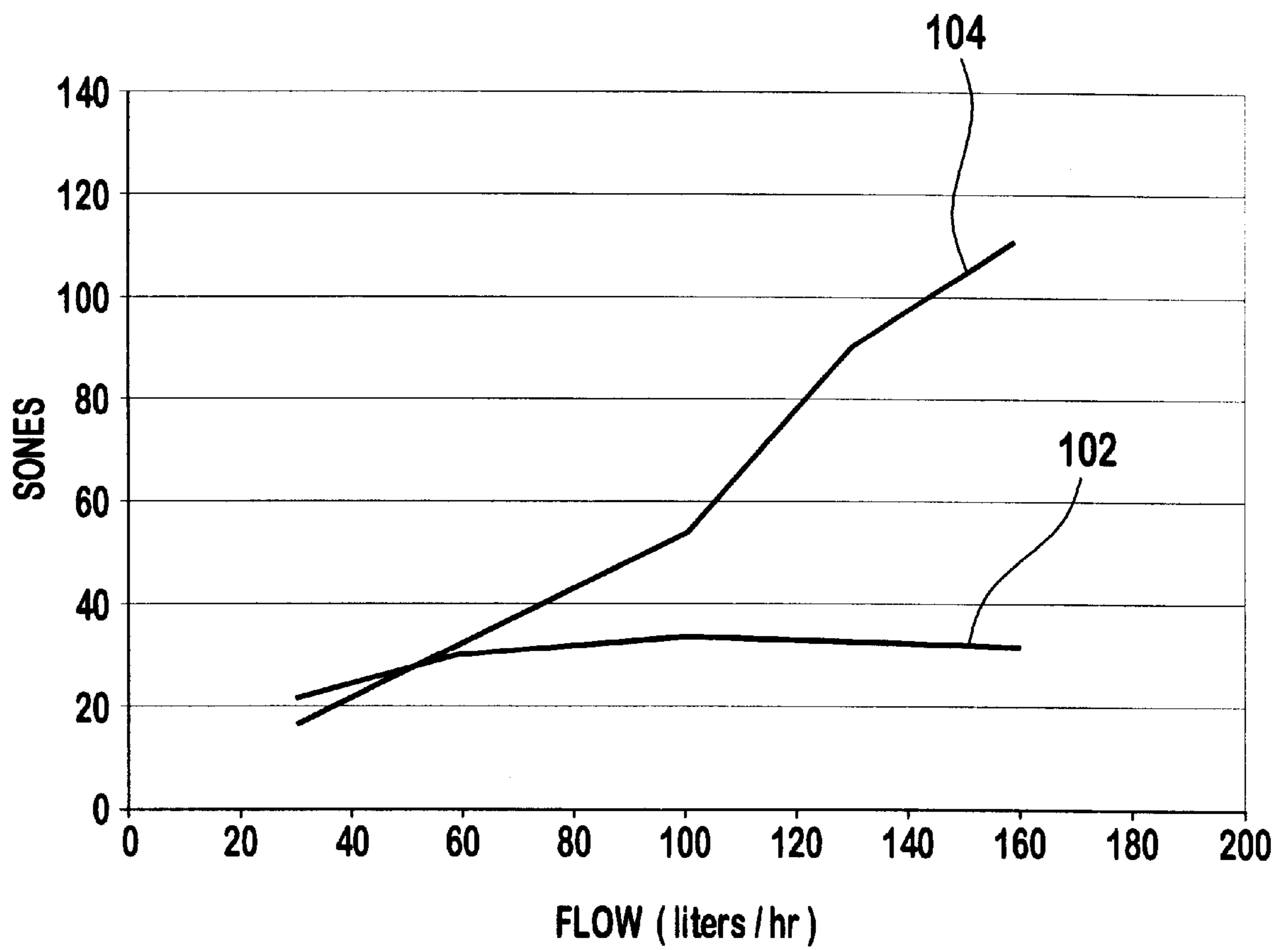
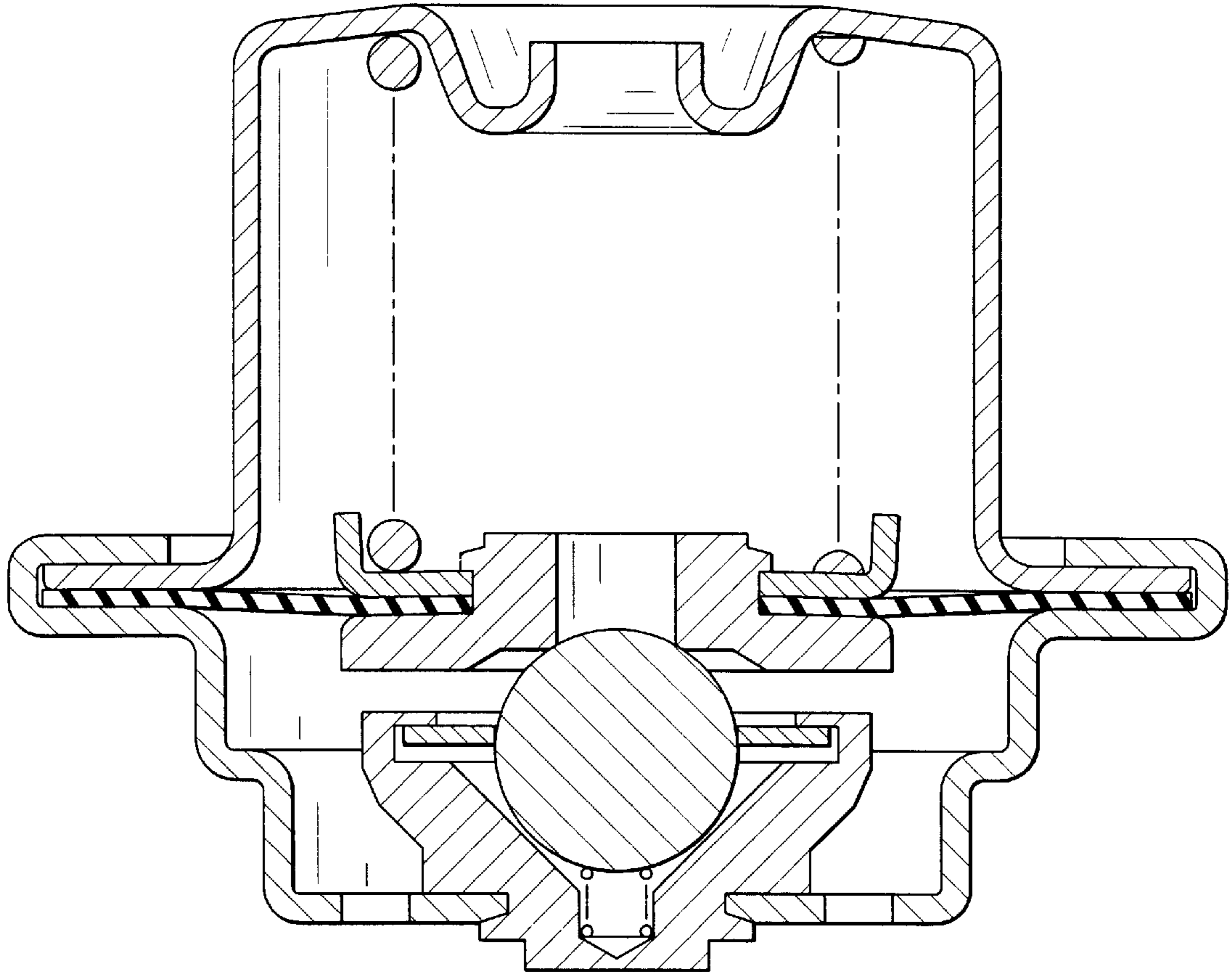


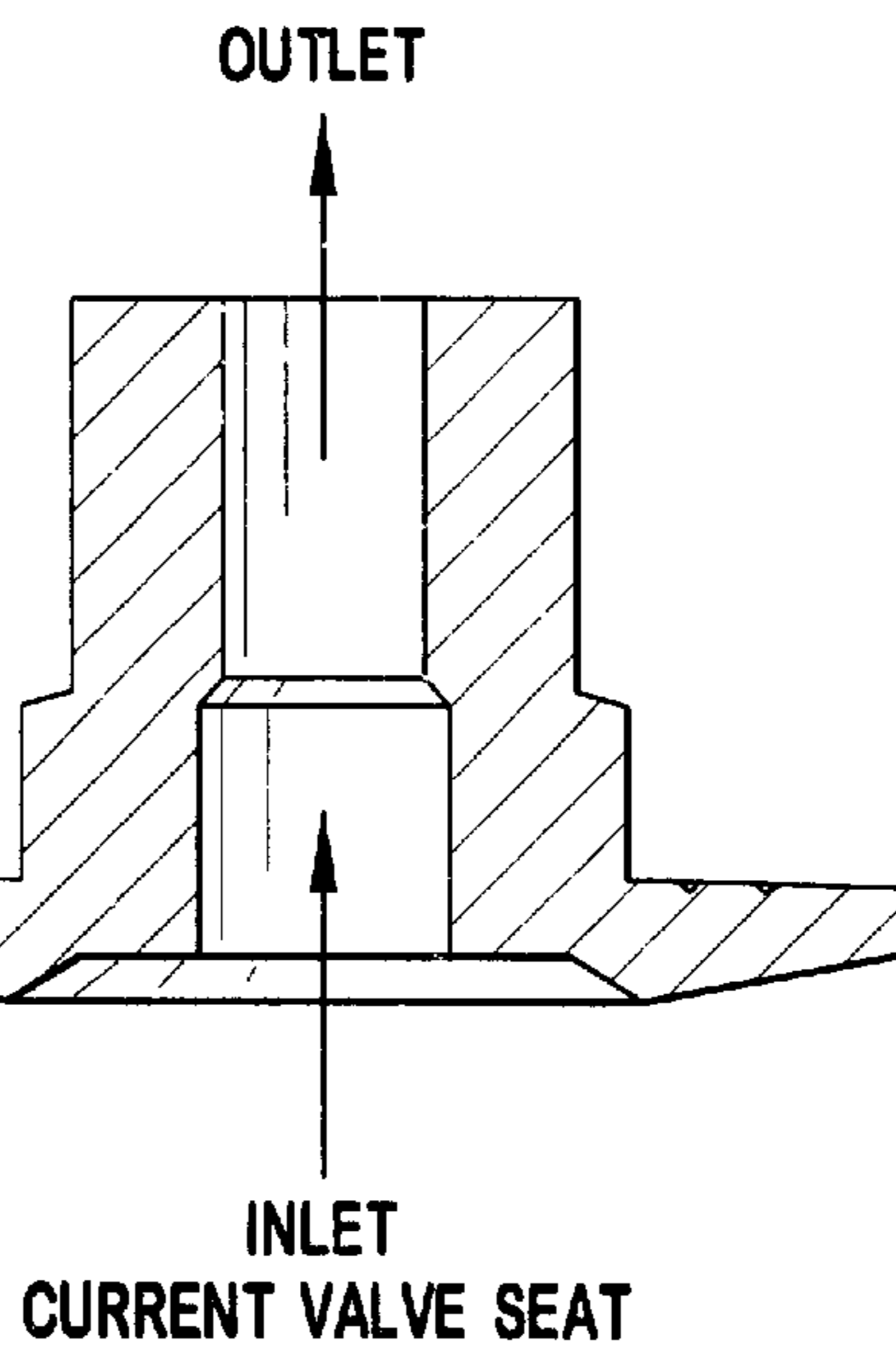
FIG. 4



**FIG. 5**  
PRIOR ART



**FIG. 6**  
PRIOR ART



## PRESSURE REGULATOR BAFFLE SEAT WITH RADIAL FLOW PATHS

### FIELD OF THE INVENTION

This invention relates to a baffle seat for a pressure regulator for automotive fuel systems, and more particularly to a baffle seat having a geometry which reduces the noise associated with high fuel flow rates through the baffle seat.

### BACKGROUND OF THE INVENTION

Most modern automotive fuel systems utilize fuel injectors to deliver fuel to the engine cylinders for combustion. The fuel injectors are mounted on a fuel rail to which fuel is supplied by a pump. The pressure at which the fuel is supplied to the fuel rail must be metered to ensure the proper operation of the fuel injectors. Metering is carried out using pressure regulators which control the pressure of the fuel in the system at all engine r.p.m. levels.

Known pressure regulators, as shown in FIG. 5, employ a spring biased valve seat with a longitudinal flow passage. A detailed view of a known valve seat is shown in FIG. 6. The valve seat is biased to a closed position to prevent the flow of fuel through the pressure regulator at low fuel pressures. As fuel pressure builds in the system, the pressure against the valve seat overcomes the biasing force of the spring, allowing fuel to flow through the valve seat, thereby controlling the fuel pressure in the system.

Fuel flow rate, measured in liters per hour, through known pressure regulators tends to be low at high engine speed; measured in revolutions per minute, as large quantities of fuel are consumed in the combustion process. And at low engine speeds, less fuel is consumed in combustion and flow rates through the pressure regulators are high. These high fuel flow rates through known pressure regulator valve seats produce unacceptably high noise levels. A valve seat is needed that maintains flow noise within acceptable levels, even at high fuel flow rates.

### SUMMARY OF THE INVENTION

The present invention provides a flow-through pressure regulator which maintains a substantially constant noise output from low fuel flow rates to high fuel flow rates. The flow-through pressure regulator includes a housing having an inlet and an outlet offset along a longitudinal axis. The housing is separated by a divider into a first chamber and a second chamber. The divider has a passage that communicates the first chamber with the second chamber. The passage includes a first section extending along the longitudinal axis and a second section extending transverse to the longitudinal axis. A closure member permits or inhibits flow through the passage.

The divider can include a baffle seat that is suspended by the divider in the housing and provides the passage. The baffle seat has a first seat portion and a second seat portion disposed along the longitudinal axis on opposite sides of the divider such that the first seat portion is disposed the first chamber and the second seat portion is disposed in the second chamber. The first section of the passage extends along the longitudinal axis through the first portion and into the second portion of the seat. The second section of the passage extends transverse to the longitudinal axis in the second portion of the seat.

The baffle seat can comprise a first surface disposed in the first chamber, a second surface disposed in the second chamber, and a side surface disposed between the first

surface and the second surface. The first section of the passage communicates with the first surface and the second section communicates with the side surface. The first section has a first wall extending from the first surface of the seat to an end wall within the second portion of the seat, and the second section has a second wall extending from the first wall to the side surface. The second wall extends from the first wall to diametrically opposed locations on the side surface, and intersects the first wall proximate the end wall.

In a preferred embodiment, the divider is a diaphragm, and a first biasing element is located in the second chamber. The closure member includes a ball disposed in a retainer. The housing includes a first cup-shaped member and a second cup-shaped member. In a preferred embodiment, the flow-through pressure regulator of the present invention has a sound rating in Sones that remains substantially constant from a low fuel flow rate to a high fuel flow rate.

The present invention also provides a low noise baffle seat for a flow-through regulator. The baffle seat has an exit geometry which reduces output noise levels at high fuel flow rates. The baffle seat includes a first seat portion having a first surface disposed about a central axis, a second seat portion having a second surface offset from the first surface along the central axis, a side surface disposed between the first surface and the second surface and a passage extending from the first surface through the first portion and the second portion to the side surface. The passage has a first section and a second section. The first section of the passage extends along the central axis in both the first portion and the second portion of the baffle seat. The second section of the passage extends transverse to the longitudinal axis in the second portion of the baffle seat. The first section communicates with the first surface and the second section communicates with the side surface.

The present invention also provides a method of stabilizing noise generation in a flow-through regulator. The flow-through regulator includes a housing with an inlet and an outlet offset along a longitudinal axis, a divider separating the housing into a first chamber and a second chamber, a passage through the divider that provides communication between the first chamber and the second chamber, and a closure member that permits or inhibits flow through the passage. The method is achieved by providing the passage with a first section extending along the longitudinal axis and a second section extending transverse to the longitudinal axis, and communicating the first section with the first chamber and the second section with the second chamber.

### BRIEF DESCRIPTION OF THE DRAWINGS

The accompanying drawings, which are incorporated herein and constitute part of this specification, illustrate presently preferred embodiments of the invention and, together with the general description given above and the detailed description given below, serve to explain features of the invention.

FIG. 1 illustrates a flow-through regulator according to the present invention.

FIG. 2 illustrates the baffle seat of the flow-through regulator shown in FIG. 1.

FIG. 3 illustrates a detailed view of the baffle seat of the present invention and a closure member.

FIG. 4 is a graph illustrating the relationship between noise and flow rate.

FIG. 5 illustrates a prior art pressure regulator.

FIG. 6 illustrates a detailed view of a prior art valve seat.

DETAILED DESCRIPTION OF THE  
PREFERRED EMBODIMENT

FIG. 1 illustrates a flow-through pressure regulator 10 according to the present invention. The flow-through pressure regulator 10 includes a housing 20. The housing 20 is separated by a divider 30 into a first chamber 40 and a second chamber 50. The divider 30 has a passage 60 that communicates the first chamber 40 with the second chamber 50. A closure member 70 permits or inhibits flow through the passage 60. A filter 80 is disposed in the flow path of the housing 20. The housing 20, has an inlet 202 and an outlet 204 offset along a longitudinal axis A. The housing 20 can include a first cup-shaped member 206 and a second cup-shaped member 208 that are crimped together to form a unitary housing 20 with a hollow interior 211. Although the unitary housing is formed by two joined members, it is to be understood that the unitary housing could be formed with multiple members integrated together or, alternatively, a monolithic member. The inlet 202 of the housing 20 is located in the first cup-shaped member 206, and the outlet 204 of the housing 20 is located in the second cup-shaped member 208. The inlet 202 can be a plurality of apertures 210 located in the first cup-shaped member 206. The outlet 204 can be a port 212 disposed in the second cup-shaped member 208.

The first cup-shaped member 206 can include a first base 214, a first lateral wall 218 extending in a first direction along the longitudinal axis A from the first base 214, and a first flange 220 extending from the first lateral wall 218 in a direction substantially transverse to the longitudinal axis A. The second cup-shaped member 208 can include a second base 222, a second lateral wall 224 extending in a second direction along the longitudinal axis A from the second base 222, and a second flange 226 extending from the second lateral wall 224 in a direction substantially transverse to the longitudinal axis A. A divider 30, which can be a diaphragm 300, is secured between the first flange 220 and the second flange 226 to separate the first chamber 40 and the second chamber 50. The first flange 220 can be rolled over the circumferential edge of the second flange 226 and can be crimped to the second flange 226 to form the unitary housing 20.

A first biasing element 90 which is preferably a spring, is located in the second chamber 50. The first biasing element 90 engages a locator 228 on the base 222 of the second cup-shaped member 208 and biases the diaphragm 300 toward the base 214 of the first-cup shaped member 206. The first biasing element 90 biases the diaphragm 300 of the regulator 10 at a predetermined force, which relates to the pressure desired for the regulator 10. The base 222 of the second cup-shaped member 208 has a dimpled center portion that provides the outlet port 212 in addition to the locator 228. The first end of the spring 90 is secured on the locator 228, while a second end of the spring 90 can be supported by a retainer 302, which is secured to a baffle seat 304 mounted in a central aperture 306 in the diaphragm 300.

FIG. 2 shows a preferred embodiment of the baffle seat 304. The baffle seat 304 is suspended by the divider 30 in the housing 20 (FIG. 1) to provide the passage 60, having a first section 602 and a second section 604. The baffle seat 304 has a first seat portion 304A and a second seat portion 304B disposed along the longitudinal axis A. The first seat portion 304A is disposed in the first chamber 40 and the second seat portion 304B is disposed in the second chamber 50 (FIG. 1). The first section 602 of the passage 60 extends along the longitudinal axis A in both the first portion 304A and the

second portion 304B of the baffle seat 304. The second section 604 of the passage 60 extends transverse to the longitudinal axis A in the second portion 304B of the baffle seat 304.

The baffle seat 304 preferably has a first surface 308 disposed in the first chamber 40 (FIG. 1), a second surface 310 disposed in the second chamber 50 (FIG. 1), and a side surface 312 extending between the first surface 308 and the second surface 310. The first section 602 of the passage 60 communicates with the first surface 308 and the second section 604 of the passage 60 communicates with the side surface 312. The first section 602 has a first wall 606 extending from the first surface 308 to an end wall 314 within the second portion 304B, and the second section 604 has a second wall 608 extending from the first wall 606 to the side surface 312. The second wall 608 can extend in opposite directions from the first wall 606 to locations on the side surface 312, and intersects the first wall 606 proximate the end wall 314. Of course, the second wall 608 can extend in a single radial direction from the first wall 606.

It should be noted that the baffle seat 304 of the present invention can be manufactured as a monolithic valve seat or, alternatively, as separate components that can be assembled. The baffle seat 304 can be used to retrofit existing valve seats having only a longitudinal flow path. For example, the separate components can comprise a cap providing an end wall 314 and a second section 604 of the passage 60.

At an end of the passage 60 opposite the end wall 314 is a seating surface 62 on which the closure member 70, which can be a valve actuator ball 64, seats. FIG. 3 shows the ball 64 seated on the valve surface 62. This surface 62 begins at an inner edge of a pocket 66 which has its side walls 68 converging toward the axis A of the baffle seat 304. This end of the baffle seat 304 opens into the first chamber 40 (FIG. 1). In the manufacturing of the baffle seat 304, the seating surface 62 is finished to assure a smooth sealing surface for the ball 64.

FIG. 3 shows that the closure member 70 can include a ball 64 disposed in a retainer 72. The retainer 72 is located in the first chamber 40 (FIG. 1), and has a flat annulus 720 secured to a valve actuator housing 722. The housing 722 can have an internal funnel 724 that includes a conical portion 726 confronting the flat annulus 720 and a cylindrical portion 728 occluded by an end wall 729. The conical portion 726 of the funnel 724 can support the ball 64. The cylindrical portion 728 of the funnel 724 supports a spring 74 that biases the ball 64 toward the divider 30 (FIG. 1). The conical portion 726 is sized so as to not interfere with the movement of the ball 64. The ball 64 is retained by the flat annulus 720 on a ball surface opposite the spring 74. The annulus 720 has a central aperture 720A that is somewhat smaller than the diameter of the ball 64. The aperture 720A is finished to prevent a rough surface from contacting the ball 64. At the wide end of the funnel 724 there is formed a pocket 76. The annulus 720, which is located above the major diameter of the ball or its horizontal axis, is located in the pocket 76 against the inside of the upper edge of the valve actuator housing 722. The annulus 720 has an outside diameter which is smaller than the diameter of the pocket 76 of the housing 722 and can be retained against separation from the housing 722 by crimping of the upper edge 722A of the valve actuator housing 722 over the annulus 720. The annulus 720 is not held tightly in the pocket 76 at the end of the funnel 724, but is free to move both axially and radially in the pocket 76.

One method of assembling the fuel regulator 10 is by first securing the valve actuator housing 722 to the first cup-



shaped member **206**. The small bias spring **74** is placed in the bore **728**. The ball **64** is then located in the conical portion **726** of the funnel **724** formed in the valve actuator housing **722**. Next, the annulus **720** is placed in the pocket **76** on the upper edge of the housing **722** and the edges **722A** of the housing **722** are crimped over to retain the annulus **720** in the pocket **76**. The baffle seat **304** is located and secured in the central aperture **306** of the diaphragm **300** between a flange **304C** of the baffle seat member **304** and the spring retainer **302**. This completed diaphragm is located on the upper flange surface **220** of the first cup-shaped member **206**. The bias spring **90** is positioned in the spring retainer **302** and the second cup-shaped member **208** is then placed over the spring **90** and located on the diaphragm **300**. The flange **220** of the first cup-shaped member **206** is crimped down to secure the second cup-shaped member **208**. The first and second cup-shaped members **206,208** and the diaphragm **300** form a unitary member. The pressure at which the fuel is maintained is determined by the spring force of the bias spring **90**.

The operation of the flow-through pressure regulator will now be described. The bias spring **90** acts through the retainer **302** to bias the divider **30** toward the base **214** of the first cup-shaped member **206**. The spring **74** functions to bias the ball **64** against the seating surface **62** in the baffle seat member **304**. When the ball **64** is seated against surface **62**, the baffle seat is in a closed position and no fuel can pass through the regulator.

Fuel enters the regulator **10** through apertures **210** and exerts pressure on the divider **30**. When the pressure of the fuel is greater than the force exerted by the large bias spring **90**, the diaphragm **300** moves in an axial direction and the ball **64** leaves the seating surface **62** of the baffle seat member **304**. Fuel can then flow through the regulator **10**. The fuel enters the first section **602** of the passage **60**, then passes into the second section **604**. In the second section **604**, the fuel is diverted transversely to the longitudinal axis **A**, and leaves the baffle seat **304** through the side surface **312**. Experimentation has shown that this exit geometry on the baffle seat provides a substantially constant noise output level from a low fuel flow rate to a high fuel flow rate.

As the fuel pressure is reduced, the force of the large bias spring **90** overcomes the fuel pressure and returns the baffle seat member **304** to seated engagement with the ball **64**, thus closing the passage **60** in the baffle seat member **304**.

As shown in FIG. 4, curve **102** shows that noise is generally consistent over a range of flow rates according to the present invention. In contrast, curve **104** shows that noise increases substantially as flow increases through conventional regulators.

While the invention has been disclosed with reference to certain preferred embodiments, numerous modifications, alterations, and changes to the described embodiments are possible without departing from the sphere and scope of the invention, as defined in the appended claims and their equivalents thereof. Accordingly, it is intended that the invention not be limited to the described embodiments, but that it have the full scope defined by the language of the following claims.

What we claim is:

**1.** A flow-through pressure regulator, comprising:

a housing having an inlet and an outlet offset along a longitudinal axis;

a divider separating the housing into a first chamber and a second chamber, the divider having a passage that communicates the first chamber with the second

chamber, the passage including a first section extending along the longitudinal axis and a second section extending transverse to the longitudinal axis; and  
a closure member that permits or inhibits flow through the passage.

**2.** The flow-through regulator of claim **1**, wherein the divider comprises a seat, the seat being suspended by the divider in the housing to provide the passage, the seat having a first seat portion and a second seat portion disposed along the longitudinal axis, the first seat portion being disposed in the first chamber, a second seat portion being disposed in the second chamber, the first section of the passage extending along the longitudinal axis in both the first portion and the second portion of the seat, and the second section of the passage extending transverse to the longitudinal axis in the second portion of the seat.

**3.** The flow-through regulator of claim **2**, wherein the seat comprises a first surface disposed in the first chamber, a second surface disposed in the second chamber, and a side surface disposed between the first surface and the second surface.

**4.** The flow-through regulator of claim **3**, wherein the first section communicates with the first surface and the second section communicates with the side surface.

**5.** The flow-through regulator of claim **4**, wherein the first section comprises a first wall extending from the first surface to an end wall within the second portion, and wherein the second section comprises a second wall extending from the first wall to the side surface.

**6.** The flow-through regulator of claim **5**, wherein the second wall extends from the first wall to diametrically opposed locations on the side surface, and intersects the first wall proximate the end wall.

**7.** The flow-through regulator of claim **1**, wherein the divider comprises a diaphragm.

**8.** The flow-through regulator of claim **7**, and further comprising:

a first biasing element located in the second chamber, the first biasing element engaging a locator on an end of the second cup-shaped member and biasing the diaphragm toward an end of the first cup-shaped member.

**9.** The flow-through regulator of claim **1**, wherein the closure member comprises a ball disposed in a retainer, the retainer being located in the first chamber, and having a flat annulus secured to a housing, the housing having an internal funnel, the internal funnel including a conical portion confronting the flat annulus and a cylindrical portion with an end wall, the conical portion of the funnel supporting the ball, and the cylindrical portion of the funnel supporting a spring that biases the ball toward the divider.

**10.** The flow-through regulator of claim **1**, wherein the housing comprises a first cup-shaped member and a second cup-shaped member, the first cup-shaped member having a first base, a first lateral wall extending in a first direction along the longitudinal axis from the first base, and a first flange extending from the first lateral wall in a direction substantially transverse to the longitudinal axis, the second cup-shaped member having a second base, a second lateral wall extending in a second direction along the longitudinal axis from the second base, and a second flange extending from the second lateral wall in a direction substantially transverse to the longitudinal axis, the first flange and the second flange being secured together to provide a unitary housing.

**11.** The flow-through regulator of claim **10**, wherein the divider comprises a diaphragm secured between the first flange and the second flange to provide the first chamber and the second chamber.

**12.** The flow-through regulator of claim **1**, wherein the flow-through pressure regulator emits sound at a sound rating in Sones that remains substantially constant from a low fuel flow rate to high fuel flow rate.

**13.** A seat for a flow-through regulator, the seat comprising:

- a first seat portion having a first surface disposed about a central axis;
- a second seat portion having a second surface offset from the first surface along the central axis;
- a side surface disposed between the first surface and the second surface; and
- a passage extending from the first surface through the first portion and the second portion to the side surface, the passage having a first section and a second section, the first section of the passage extending along the central axis in both the first portion and the second portion of the seat, the second section of the passage extending transverse to the central axis in the second portion of the seat, the first section communicating with the first surface and the second section communicating with the side surface.

**14.** The seat of claim **13**, wherein the first section comprises a first wall extending from the first surface to an end wall within the second portion, and wherein the second section comprises a second wall extending from the first

**15.** The seat of claim **14**, wherein the second wall extends from the first wall to diametrically opposed locations on the side surface, and intersects the first wall proximate the end wall.

**16.** A method of stabilizing noise generation in a flow-through regulator, wherein the flow-through regulator includes a housing with an inlet and an outlet offset along a longitudinal axis, a divider separating the housing into a first chamber and a second chamber, the divider including a passage that provides communication between the first chamber and the second chamber, and a closure member that permits or inhibits flow through the passage, the method comprising:

providing the passage with a first section extending along the longitudinal axis and a second section extending transverse to the longitudinal axis; and

communicating the first section with the first chamber and the second section with the second chamber.

**17.** The method of claim **16**, further comprising:

- providing the first section with a first wall;
- providing the second section with a second wall; and
- extending the second wall through the first wall to diametrically opposed locations.

**18.** The method of claim **17**, further comprising:

- suspending a seat with the divider in the housing to provide the passage, the seat having a first seat portion and a second seat portion disposed along the longitudinal axis, the first seat portion being disposed in the first chamber, a second seat portion being disposed in the second chamber, the first section of the passage extending along the longitudinal axis in both the first portion and the second portion of the seat, and the second section of the passage extending transverse to the longitudinal axis in the second portion of the seat.

**19.** The method of claim **18**, wherein the seat comprises a first surface disposed in the first chamber, a second surface disposed in the second chamber, and a side surface disposed between the first surface and the second surface, and further comprising:

- extending the first wall from the first surface to an end wall within the second portion; and extending the second wall from the first wall to the side surface.

**20.** The method of claim **19**, further comprising:

- extending the second wall from the first wall to diametrically opposed locations on the side surface; and
- intersecting the first wall with the second wall proximate the end wall.

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